



## GENERAL INFORMATION

KC2020 is a medium solids two component polyurethane clearcoat formulated to offer refinishers ease of application, very good flow and leveling, very good gloss and good distinctness of image in a productive 2K polyurethane clearcoat. KC2020 is compliant under current 2.1 VOC regulations in the United States.

### 1. COMPONENTS

- KC2020 Low VOC Urethane Clearcoat
- KH2021 Medium Activator

### 2. MIXING RATIO

Mix four (4) parts KC2020 base with one (1) part KH2021 Activator by volume. Activator selection should be based on the size of the part to be painted and the temperature of both the air and part at time of painting.

### 3. POT LIFE @ 77°F (25°C)

When properly covered at 77°F (25°C), KC2020 will maintain a sprayable viscosity for at least from 3-4 hours depending on activator selection.

### 4. ADDITIVES

ACCELERATOR: T566 up to 2% (max).  
FISHEYE: T152 Fisheye Eliminator up to 1% (max).



### 5. SURFACE PREPARATION

- Apply Undercoats and Basecoat per data sheet instructions. Over OEM or completely cured previously painted substrates scuff with a grey scuff pad or P800 grit then wipe clean with an approved solvent or water base wipe.
- Allow basecoat adequate flash time (follow manufacturer's recommendation).
- Follow basecoat manufacturer's recommendation for recoat intervals.



### 6. APPLICATION

Spray 2-3 medium-wet to wet coats. Overlap 50%.  
**Note:** Do not spray when surface temperature is below 50°F (10°C).



### 7. FLASH / DRY TIMES

**AIR DRY @ 77°F (25°C)**

Flash between coats	15-20 Minutes.
Dust Free	20-25 Minutes

#### Sand and Buff

<b>KH2021 Activated</b>
Overnight



### 9. FLASH / DRY TIMES (continued)

**FORCE DRY with HPC0 and HPC1 Activator**

Flash before Force Dry	20 Minutes
Force Dry Time	45 Minutes @ 130°F (54°C)
Sand and Buff	After Cool Down

**FORCE DRY with HPC2 and HPC3 Activator**

Flash before Force Dry	0 Minutes
Force Dry Time	15-20 Minutes @ 165°F (74°C)



### 10. INFRARED CURE

See Infrared Curing Information.



### 11. GUN SET UP

**CONVENTIONAL GUN**

Gravity Feed 1.3 mm - 1.5 mm

Siphon Feed 1.6 mm - 1.8 mm



**HVLP**

Gravity Feed 1.3 mm - 1.5 mm

#### AIR PRESSURES

**Conventional @ Gun**

Gravity Feed 35-40 psi (2.5-2.8 bar)

Siphon Feed 35-45 psi (2.5-3.1 bar)

**HVLP Inlet Air**

30 psi (2.0 bar)

See spray gun manufacturer info



### 12. PHYSICAL DATA

VOC	2.1 lbs./gal.
Volume Solids	35.3%
Theoretical Coverage	566 sq. ft. per mil/25 µm per gallon
Recommended DFT	1-4 mils/25-100 µm
Zahn #2 Viscosity (RTS)	19 - 21 Seconds
Din cup #4 mm	16 - 18 Seconds